

Date: Friday, 04/04/2008 9:22:00 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 38394		
Estimate Number	: 10346		
P.O. Number	:	Part Number	: D2596
This Issue	: 04/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2596 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	: 38294	Drawing Revision	: D
	Type : LANDING GEAR	Material	:
Written By	:	Due Date	: 21/04/2008
Checked & Approved By	: <u>JO 08.04.4</u>	Qty:	16 Um: Each
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Extr'n -I" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B.33 940

JD 8-4-9

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

JD 8-4-9

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

JD 8-4-9

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

DP

8-4-9

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:00 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 38394

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Skid tube cell

DP

8-4-9

(16)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

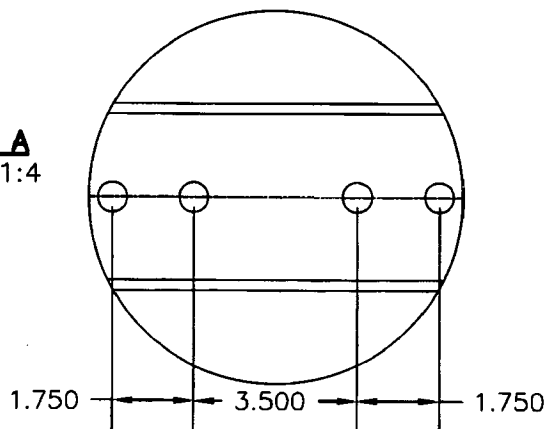
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



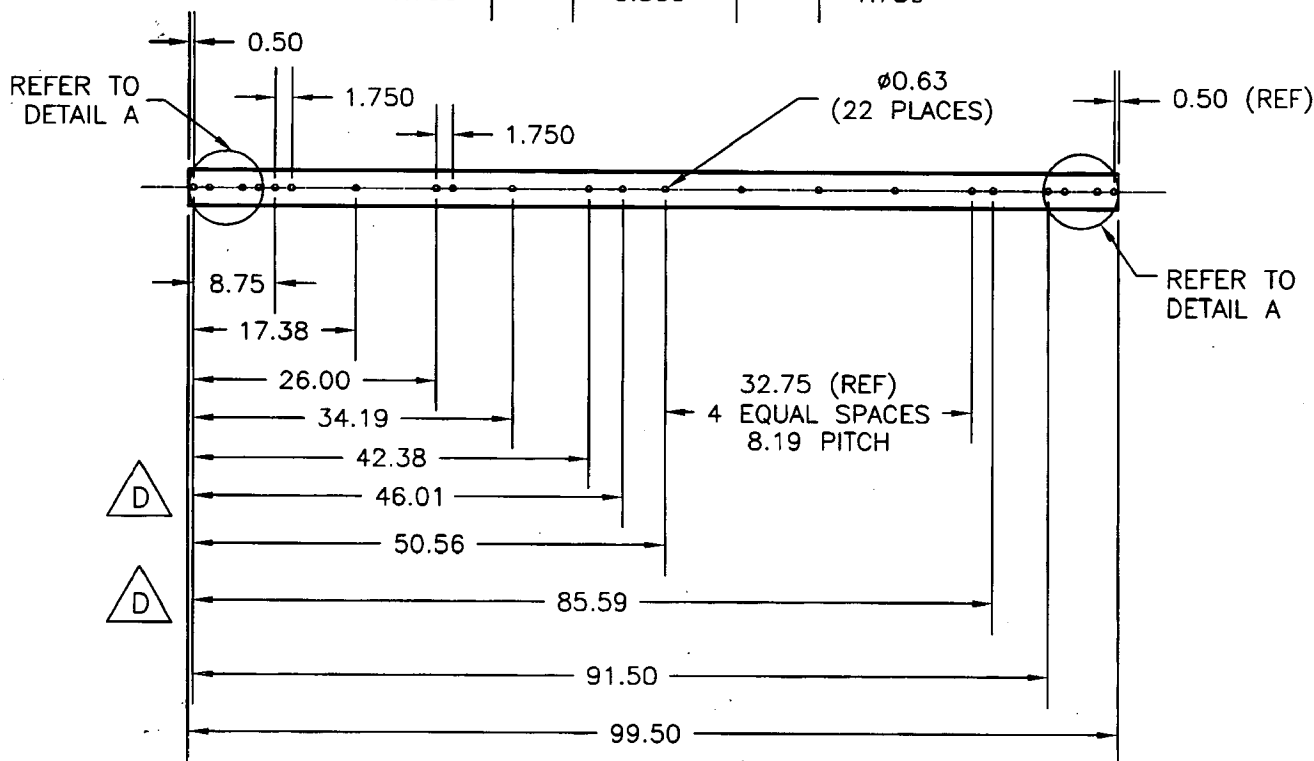
RELEASED
07.06.18

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
04	04	DRAWING NO.	D2596	SHEET 1 OF 1
CHECKED H	APPROVED H	TITLE	205 WEB	SCALE 1:20
DATE 07.04.17				
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		



DETAIL A
SCALE 1:4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38394



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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